

531.

DART AEROSPACE LTD	Work Order:	23935
Description: Skidtube Material	Part Number:	D6013-047
Dwg: D6013 Rev. A	Qty:	108
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	AK	05/09/07	108
2	PG	Issue P/O: <u>2007829</u> a) Extrude as per Dwg D6013 b) Material: 7075-T73/T73510/T73511 (QQ-A-200/11) Seamless Aluminum Tube c) Minimum ultimate tensile strength = 66 ksi d) Minimum tensile yield strength = 56 ksi Possible Supplier: Aluminum Works Material certification is required	UA	05/04/07	108
3	RG	Receive and Inspect for transit damage Ensure Material certification is attached	CY	05/08/09	108
4	QC6	Inspect dimensions as per Dwg D6013 Ensure Material certification complies with Dwg D6013	BG	05.10.18	100
5	FP	Chemical Conversion Coat as per QSI 005 4.1			
6	QC3	Inspect Chemical Conversion Coat			
7	ST	Identify and Stock	U	05.11.22	98
8	AC	Cost / part: _____	SUC	05-11-23	98
9	DC	Close W/O Inspect Level 21	D	05/11/23	98

Rev	Date	Change	Revised By	Approved
A	05.08.31	New issue	KJ/JLM	

RELEASED
05/05/01

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA:  Date: 05/11/08

NOTE: Date & initial all entries

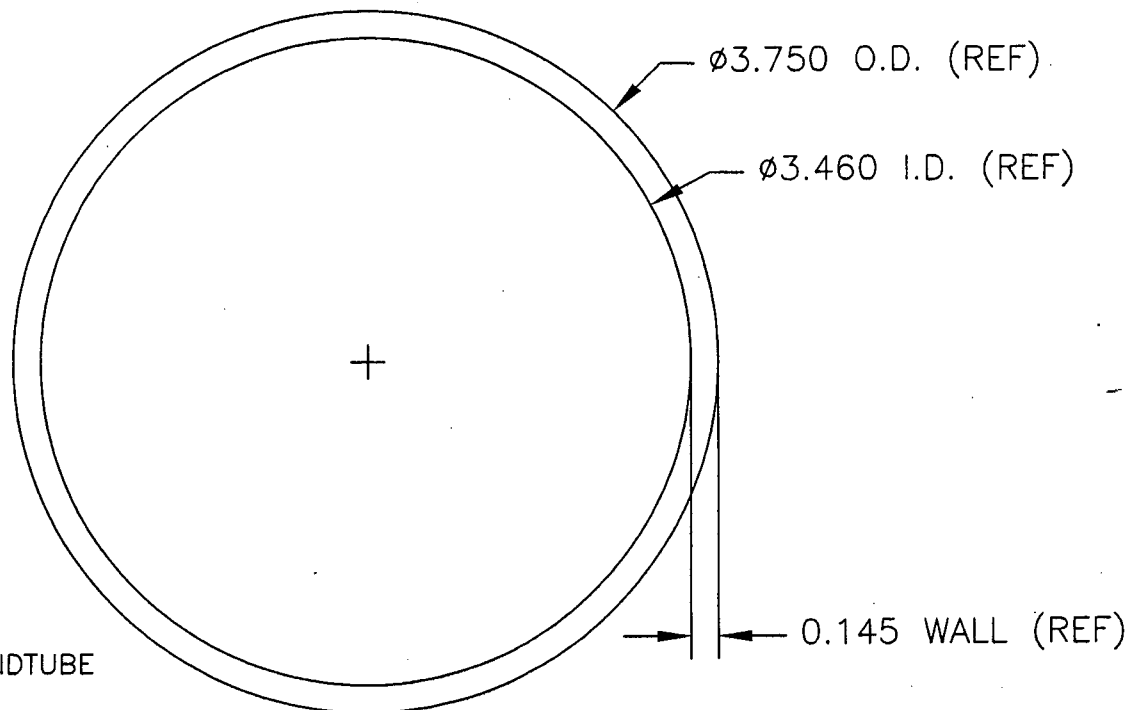
QA: N/C Closed: _____ Date: _____

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6013	REV. A SHEET 1 OF 1
DATE 05.03.18	TITLE SKIDTUBE MATERIAL		SCALE 1:1
A	05.03.18	NEW ISSUE	

RELEASED
05-08-09 #

SPECIFICATION CONTROL DRAWING



NOTES

- 1) D6013-XXX SKIDTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 47" LONG TUBE: D6013-047

- 2) MATERIAL: 3.750 OD x 0.145 WALL 7075-T73/T73510/T73511 PER QQ-A-200/11 SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 66 ksi
MINIMUM YIELD TENSILE STRENGTH = 56 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.006 MEAN (± 0.015 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.188/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH
- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

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ENGINEERING

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SUBJECT TO ENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 023935

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 16, 2005
08:32 am

Work Order No : 0023935
Project Name : D6013-047
Project For : WK531
Work Order Type : Main
Main WO Number :
House Part Number : D6013-047
Description : SKIDTUBE MAT'L
Manufactured : No
Amount Req'd : 128
Amount Done : 0
Start Date : 08-03-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	9692.78	100.00	0.00	9692.78
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	9692.78	100.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	9692.78			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-9692.78)

order confirmation

13732

page: 2
date: 23.05.2005
customer 40980

Outside surface: max. defects up to 0.005" (longitudinally)
Min. ultimate tensile strength 68 ksi
Min. yield strength 57 ksi
Tubes protected with corrosion protective oil
Tubes line marked
Packing list, Inspection certificate
Packing: seaworthy wooden cases

item	quantity	unitprice	USD	unit value	USD	despatch date:
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003	128,000	PC	74,79	PC	9.573,12	2005:30
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section 2 of 08/09

AWU article: 19447 / Tariff no. 76082099

Customer article: D6013-047 3.750 X 0.145 X 47

product: TUBES / seamless extruded and drawn / EN AW-7075 / round

condition: T 73 / AMS-WWT-700/7B

outer diameter:	3,750 INCH Tol.	+0,016	-0,016
tol. for mean OD		+0,008	-0,008
inner diameter:	3,460 INCH		
wall thickness:	0,145 INCH Tol.	+0,015	-0,015
tol. for mean wall		+0,006	-0,006
fixed length	47,000 INCH Tol.	+0,188	

test report acc. to EN 10204/3.1 / RM 455 / Rp0,2: 386

straightness 0,01 INCH / 1 FEET / RMS outer 25

tol. on quantity +10 % -10 %

3.750" OD 0.145" Wall, 47" lengths

7075-T73, AMS-WW-T-700/7B

Part Number D6013-047 skidtube

~~Surface Finish max. RMS 25 max. centerless grinded~~

Tolerances per ASTM B210

Tubes protected with corrosion protective oil

Tubes line marked

Packing list, Inspection certificate

Packing: seaworthy wooden cases

terms of delivery: DDP (Delivered, Duty, Paid)

Terms of payment: 30 days after date of delivery

delivery address:

Dart Aerospace Ltd.
1270 Aberdeen Street
CDN K6A1K7 Hawkesbury
ON